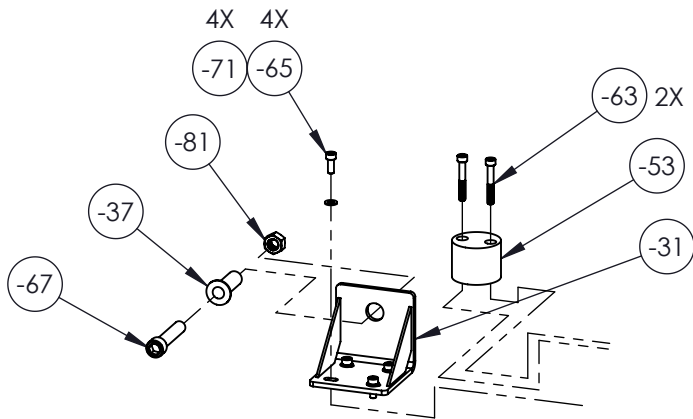
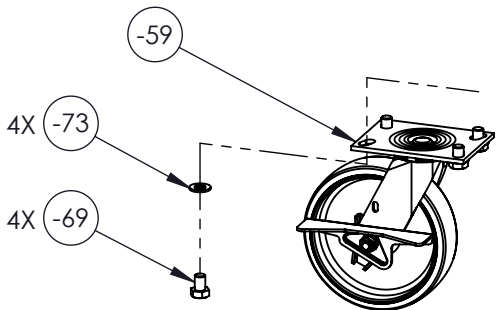


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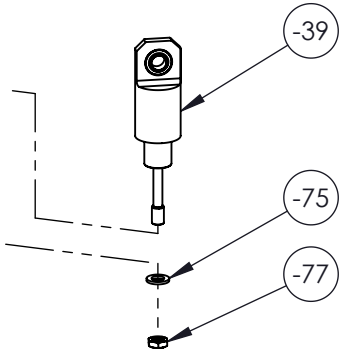
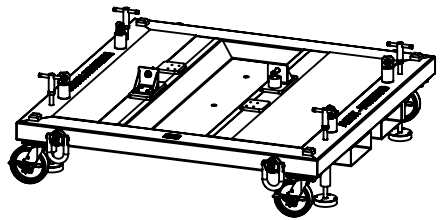
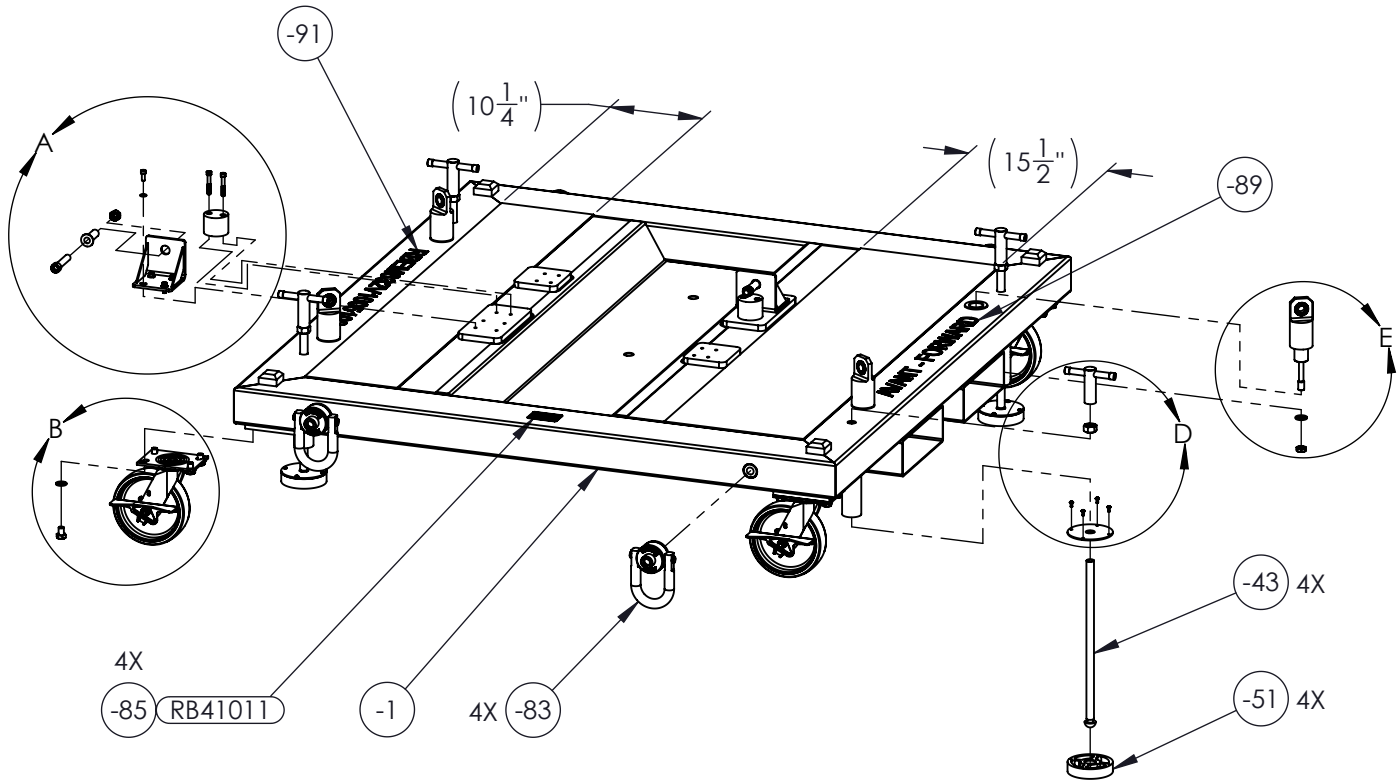
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/22/2016	DPD	JAG
2	16-0182	-1 ADDED DIM 17.20, 2X 19.87, 12.25, 67.00, 69.38; CH'D DIM WAS 39.67 IS (39.67) WAS 40.94 IS (40.94). -3 -5 -7 -21 CH'D DIM WAS .13 IS .12 -25 CH'D DIM WAS .09 IS .11. -27 CH'D DIM WAS .09 IS .11. -29 CH'D DIM WAS M20X2.5 - 6H $\Psi$ 1.58 IS 7/8-9 UNC-2B $\Psi$ 1.75. -41 ADDED DIM .05 X 45°. ADDED NOTE "CENTER OK". -45 CH'D DIM WAS $\varnothing$ .6014/.5986 S.F. -47 IS $\varnothing$ .6014/.5986 (S.F. -47). -47 CH'D DIM WAS $\varnothing$ .6114/.6074 $\Psi$ .13 S.F. -45 IS $\varnothing$ .6114/.6074 $\Psi$ .13 (S.F. -45). -53 CH'D DIM WAS 2X $\varnothing$ .29 THRU ALL L $\varnothing$ .43 $\Psi$ .25 IS 2X $\varnothing$ .39 THRU ALL L $\varnothing$ .59 $\Psi$ .32. -83 CH'D B/O INFORMATION WAS M20 X 2.5mm (CROSBY #1016657) IS 7/8-9 UNC (CROSBY #1016957). ADDED -85 -89 ADDED TO BOM QTY 1. ADDED DRAWING. -91 ADDED TO BOM QTY 1. ADDED DRAWING.	10/20/2016	SM	JAG



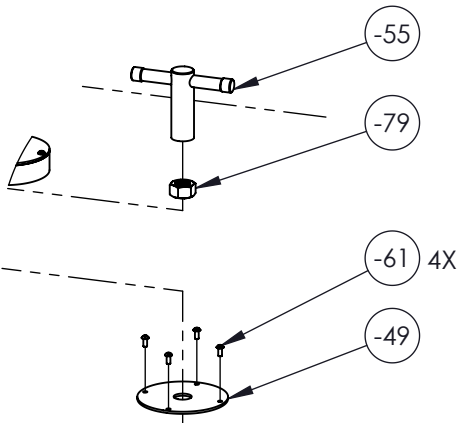
DETAIL A  
SCALE 1 : 10  
2 PLACES



DETAIL B  
SCALE 1 : 10  
4 PLACES




DETAIL E  
SCALE 1 : 10  
4 PLACES



DETAIL D  
SCALE 1 : 10  
4 PLACES

**SEE ATTACHED DEVIATION**

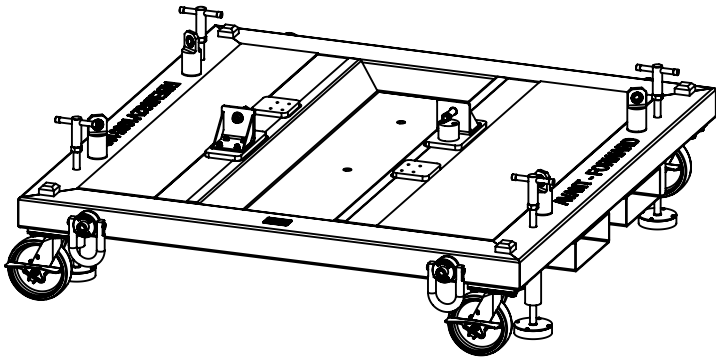
NOTE:  
REF. AIRBUS T/N: M632V1005102.

<div></div>			
TITLE TRANSMISSION STAND			
DWG NO. RBEM632V1005102			REV 2
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$ .005 FRACTIONS $\pm$ 1/8 .XX $\pm$ .01 ANGLES $\pm$ 5° .X $\pm$ .1 SURFACES = 125/ $\sqrt{\hspace{1cm}}$	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE 1:20	DATE 12/11/2015	SHEET 1 OF 31	


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-83 CH'D B/O INFORMATION WAS M20 X 2.5mm (CROSBY #1016657) IS 7/8-9 UNC (CROSBY #1016957). ADDED -85. -89 ADDED TO BOM QTY 1. ADDED DRAWING. -91 ADDED TO BOM QTY 1. ADDED DRAWING.	2/3/2017	SM	JAG

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			X		-1	1	BASE WELDMENT			3
			2		-3		FRONT & REAR TUBE	STEEL		4
			2		-5		SIDE TUBE	STEEL		5
			2		-7		MID TUBE	STEEL		6
			4		-9		ANCHOR POCKET	4140/4142		7
			4		-11		SQUARE LUG	A36/1018/1020 HR		8
			4		-13		JACKSCREW BASE	4140/4142		9
			4		-15		WHEEL PLATE	A36/1018/1020 HR		10
			2		-17		SMALL MOUNT PLATE	A36/1018/1020 HR		11
			2		-19		LARGE MOUNT PLATE	A36/1018/1020 HR		12
			8		-21		FORK POCKET	STEEL		13
			1		-23		BOTTOM PAN	A36/1018/1020 HR		14
			1		-25		SMALL COVER	A36/1018/1020 HR		15
			1		-27		LARGE COVER	A36/1018/1020 HR		16
			4		-29		TIE DOWN ANCHOR	4140/4142		17
		X			-31	2	BRACKET WELDMENT			18
		1			-33		BRACKET	A36/1018/1020 HR		19
		2			-35		BRACKET GUSSET	A36/1018/1020 HR		20
					-37	2	BUSHING	4140/4142		21
	X				-39	4	ANCHOR ASSEMBLY			22
	1				-41		ANCHOR	4140/4142		23
X					-43	4	JACKSCREW ROD WELDMENT			24
1					-45		JACKSCREW ROD	B7	M20 X 2.5mm X 500mm (MCMASTER-CARR #93325A442) MODIFIED	25
1					-47		JACKSCREW ROD PIVOT	4140/4142		26
					-49	4	JACKSCREW COVER	A36/1018/1020 HR		27
					-51	4	JACKSCREW FOOT	4140/4142		28
					-53	2	DELRIN PAD	WHITE DELRIN/ACETAL		29
				B/O	-55	4	JACKSCREW HANDLE	STEEL	M20 X 2.5mm X 3.74 (J.W. WINCO #20NB20)	1
	1			B/O	-57		SPHERICAL BEARING	STEEL	Ø.787 I.D. X Ø1.378 O.D. X .472 (SKF #GE 20 ES-2RS)	22
				B/O	-59	4	CASTER WITH BRAKE		Ø8 (COLSON #4.08199.939 MTG2BRK3)	1
				B/O	-61	16	BUTTON HEAD SOCKET CAP SCREW	S.S.	M5 X 0.8 X 12mm (MCMASTER-CARR #92095A210)	1
				B/O	-63	4	SOCKET HEAD CAP SCREW	S.S.	M8 X 1.25 X 55mm (MCMASTER-CARR #91292A156)	1
				B/O	-65	8	SOCKET HEAD CAP SCREW	STEEL	M8 X 1.25 X 20mm (MCMASTER-CARR #90128A274)	1
				B/O	-67	2	SOCKET HEAD CAP SCREW	S.S.	M16 X 2 X 80mm (MCMASTER-CARR #91292A247)	1
				B/O	-69	16	HEX HEAD CAP SCREW	STEEL	M14 X 1.5 X 20mm (MCMASTER-CARR #91180A774)	1
				B/O	-71	8	WASHER	STEEL	M8 (MCMASTER-CARR #91166A270)	1
				B/O	-73	16	WASHER	STEEL	M14 (MCMASTER-CARR #91166A300)	1
				B/O	-75	4	WASHER	STEEL	M16 (MCMASTER-CARR #91166A310)	1
				B/O	-77	4	HEX NUT	STEEL	M16 X 2 (MCMASTER-CARR #90695A125)	1
				B/O	-79	4	HEX NUT	STEEL	M20 X 2.5mm (MCMASTER-CARR #90591A230)	1
				B/O	-81	2	HEX NUT	S.S.	M16 X 2 (MCMASTER-CARR #91828A430)	1
				B/O	-83	4	TIE DOWN	STEEL	7/8-9 UNC (CROSBY # 1016957)	1
				B/O	-85	4	SCREW NAIL	STEEL	#4 X .25 (MCMASTER-CARR # 90081A144)	1
				B/O	-87	1	CRATE	ISPM15 CERT. HT	CRATE (id) 78 X 70 X 28	N/S
				B/O	-89	1	LABEL	BLACK CUT, VINYL	SIGNS NOW	30
				B/O	-91	1	LABEL	BLACK CUT, VINYL	SIGNS NOW	31
				B/O		1	DART PLACARD	ALUMINUM	RB41011	1
ASSY -43	ASSY -39	ASSY -31	ASSY -1							

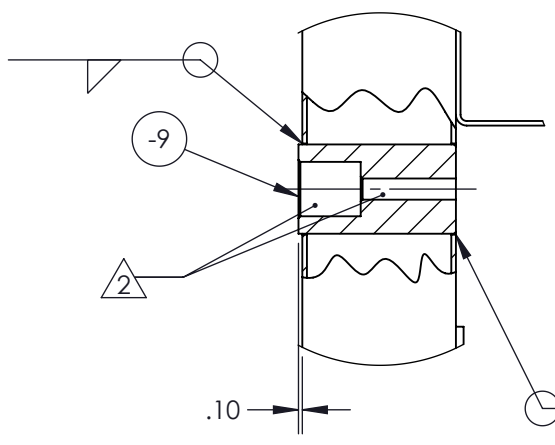
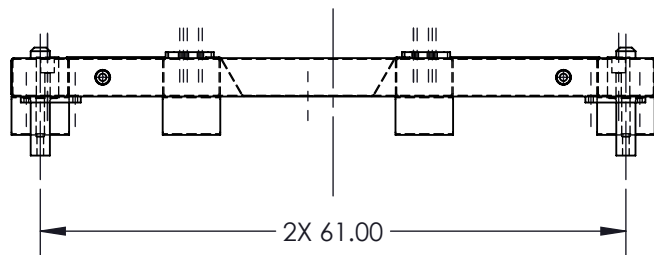
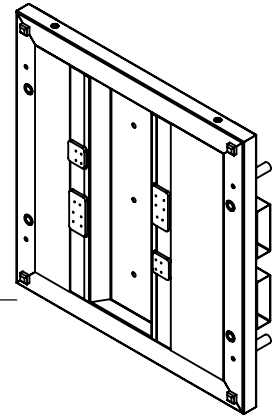
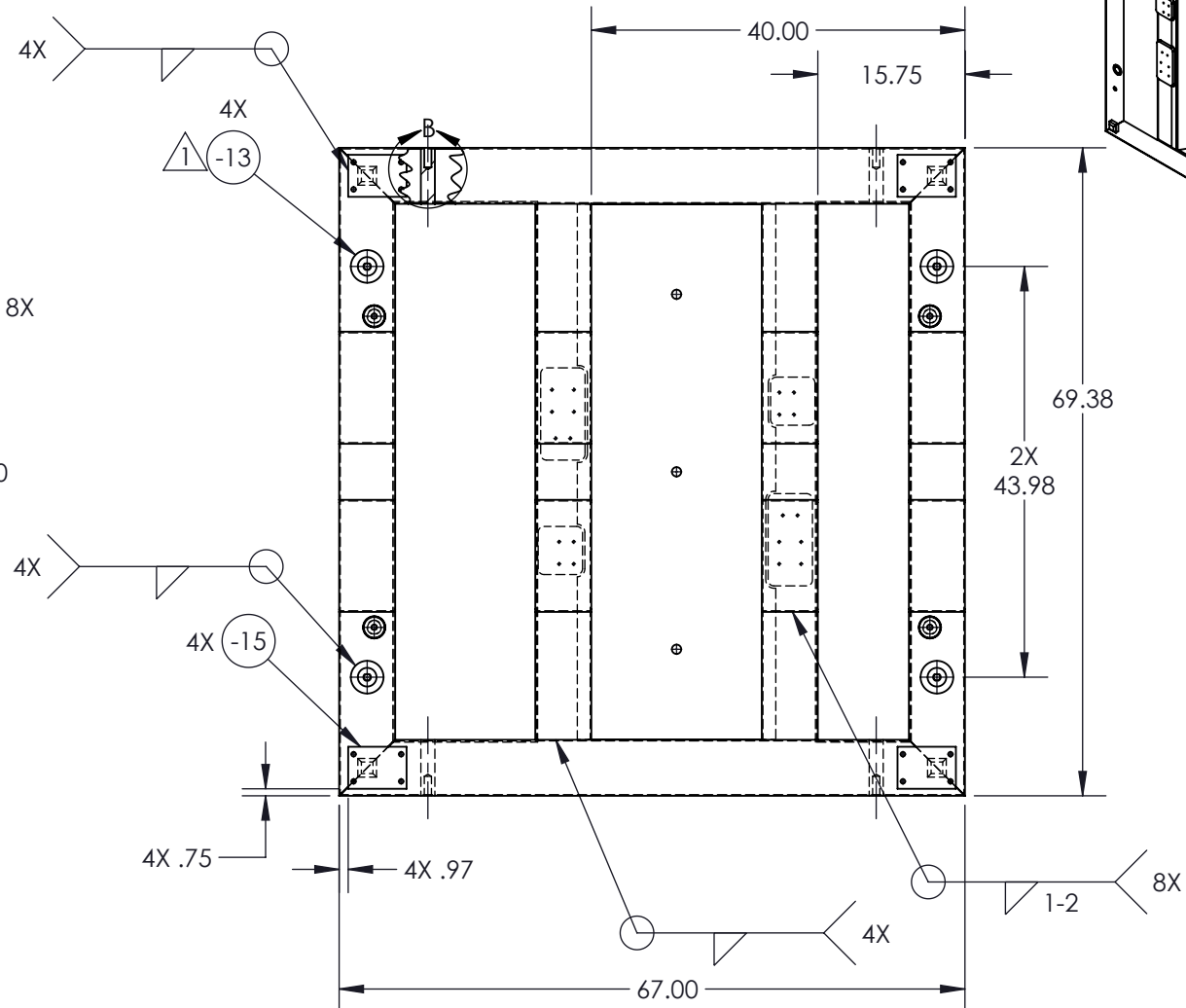
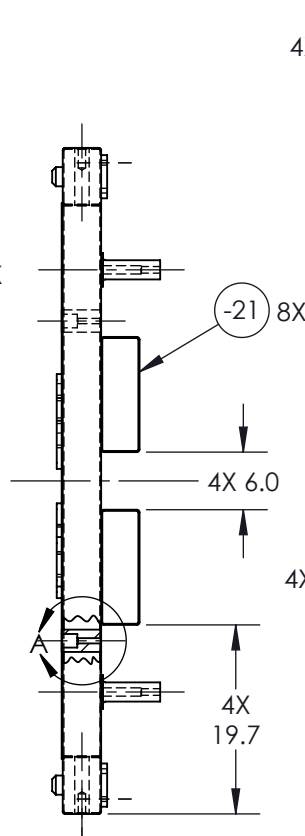
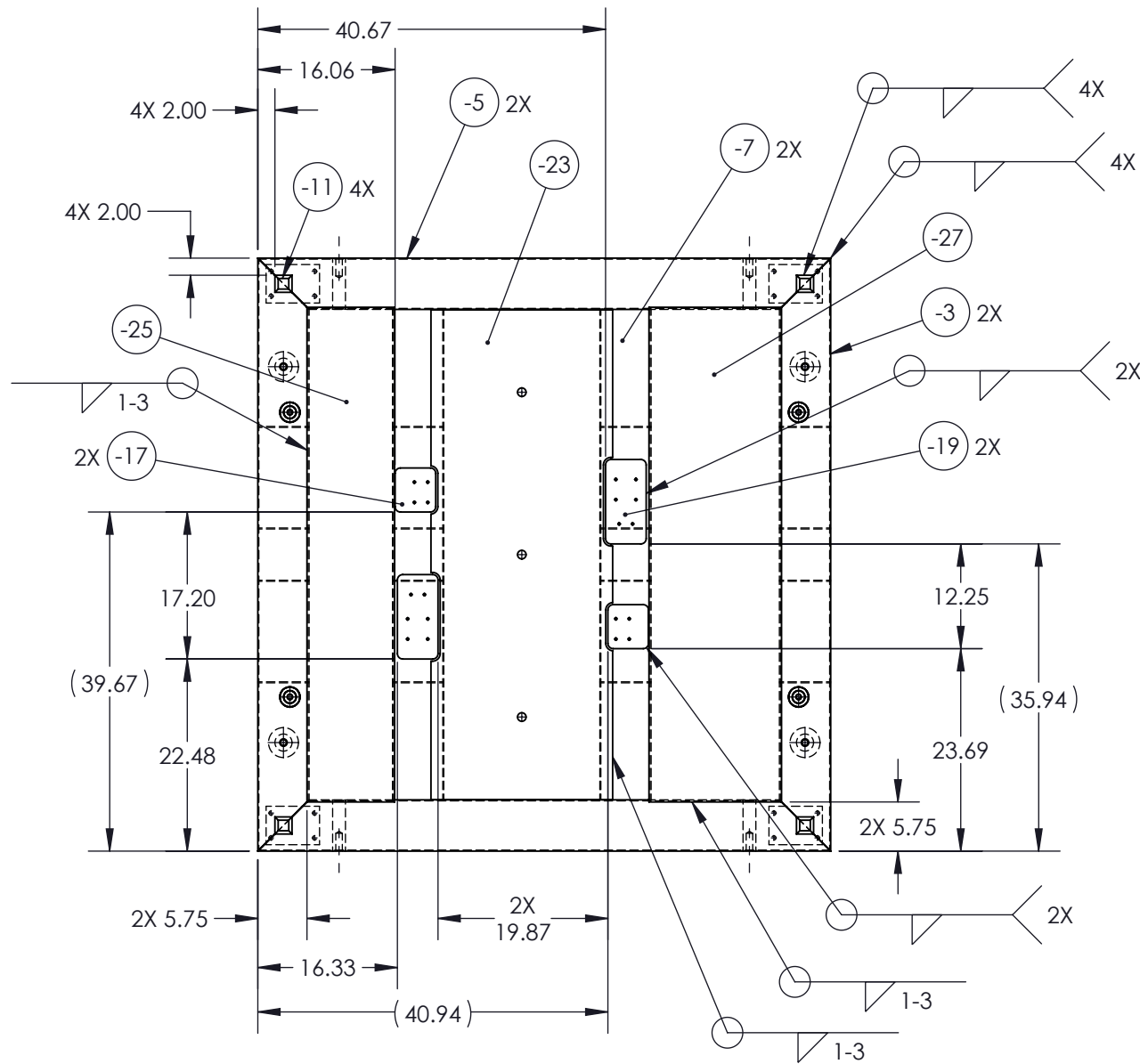


SEE ATTACHED DEVIATION

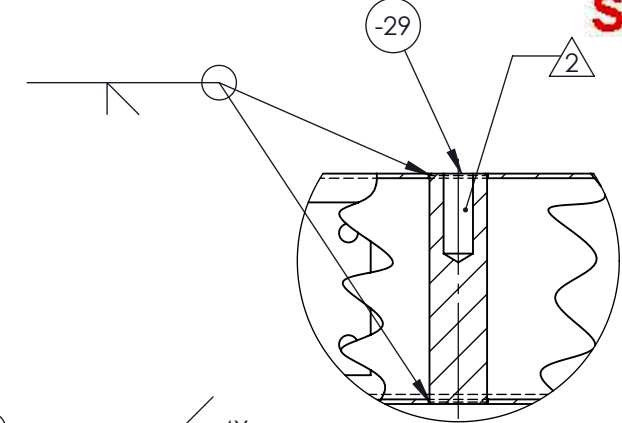
			
TITLE			
TRANSMISSION STAND			
DWG NO.			REV
RBEM632V1005102			2
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ±.5°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY:		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
APPROVED:		H175	
SCALE		DATE	
1:24		12/11/2015	SHEET 2 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-1 ADDED DIM 17.20, 2X 19.87, 12.25, 67.00, 69.38; CH'D DIM WAS 39.67 IS (39.67) WAS 40.94 IS (40.94).	10/20/2016	SM	JAG



DETAIL A  
SCALE 1 : 5  
4 PLACES



DETAIL B  
SCALE 1 : 5  
4 PLACES

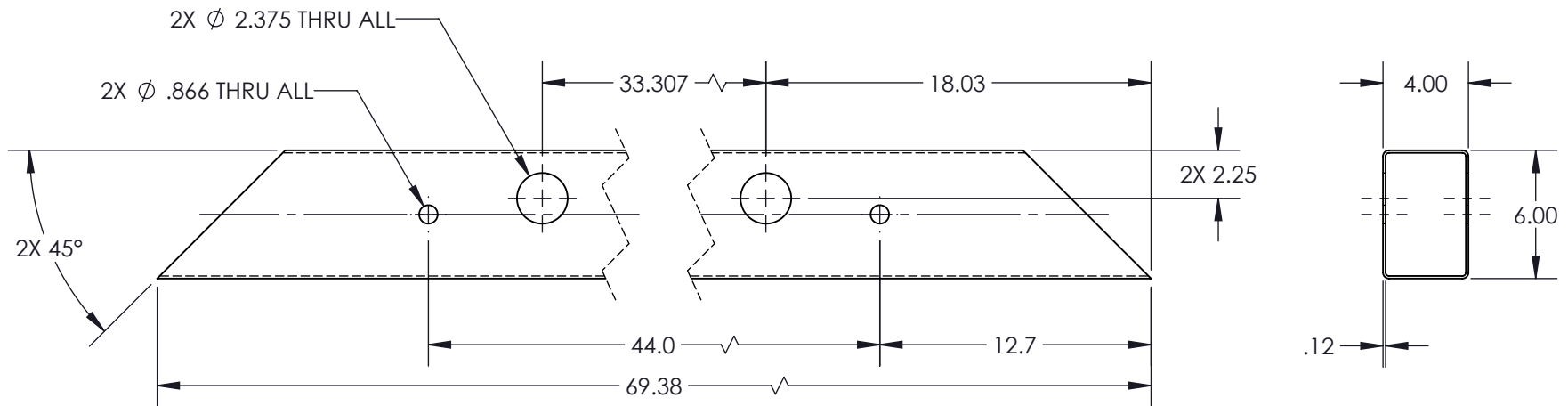
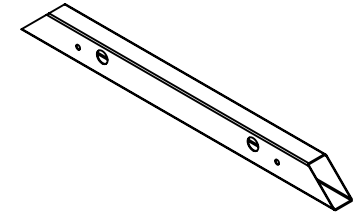
SEE ATTACHED DEVIATION

- NOTE:
- 1 HOLES MUST ALIGN.
  - 2 NO POWDER COAT THIS SURFACE.

DART AEROSPACE			
TITLE TRANSMISSION STAND			
DWG NO. RBEM632V1005102-1			REV 2
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL H175	
APPROVED: GILBERT		SCALE 1:20 DATE 12/11/2015 SHEET 3 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-3 CH'D DIM WAS .13 IS .12.	10/20/2016	SM	JAG



**SEE ATTACHED DEVIATION**

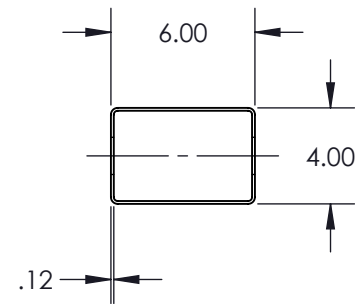
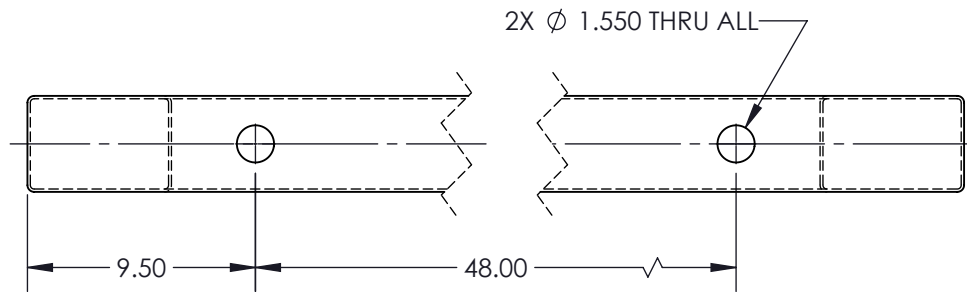
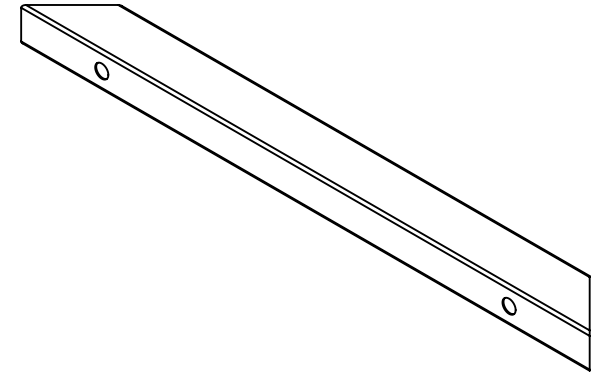
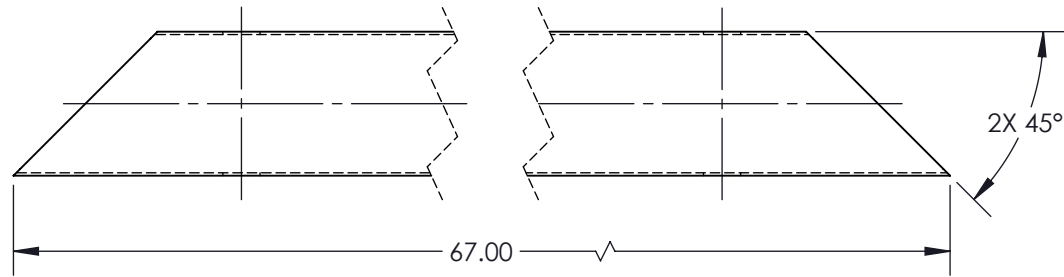
(-3)

FRONT & REAR TUBE

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-3	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 12/11/2015
SHEET 4 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-5 CH'D DIM WAS .13 IS .12.	10/20/2016	SM	JAG



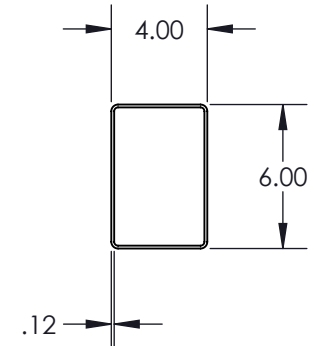
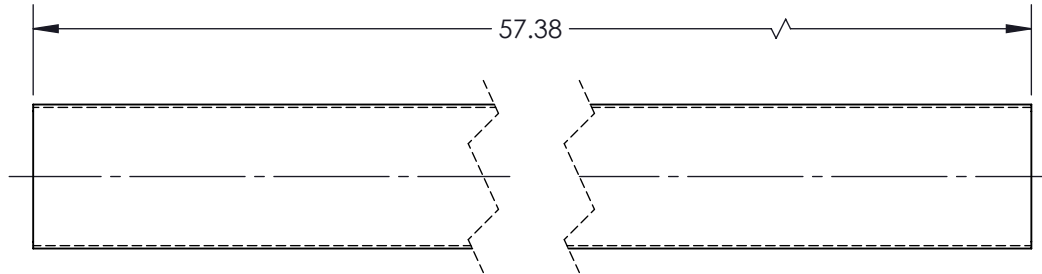
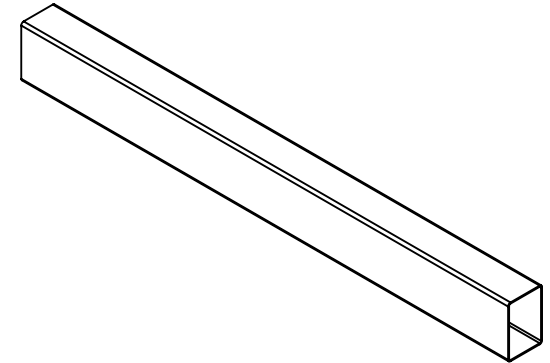
**SEE ATTACHED DEVIATION**

(-5)  
SIDE TUBE

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-5	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 12/11/2015
SHEET 5 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-7 CH'D DIM WAS .13 IS .12.	10/20/2016	SM	JAG



**SEE ATTACHED DEVIATION**

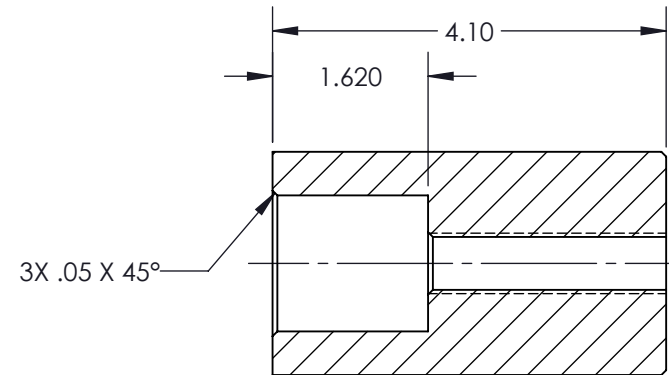
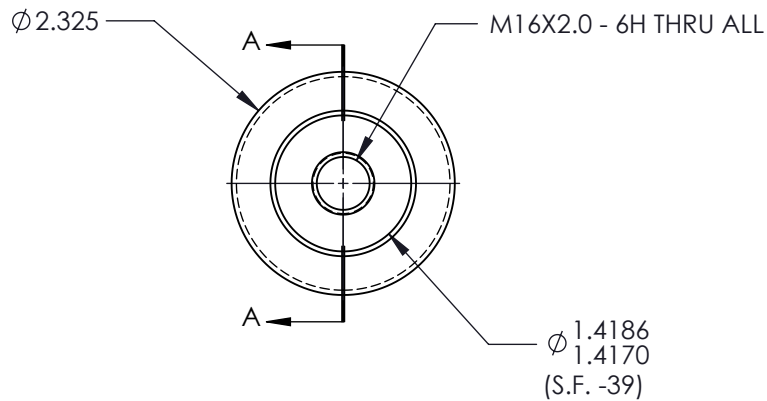
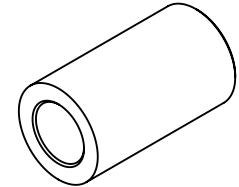
(-7)

MID TUBE

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-7	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 12/11/2015
SHEET 6 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A

**SEE ATTACHED DEVIATION**

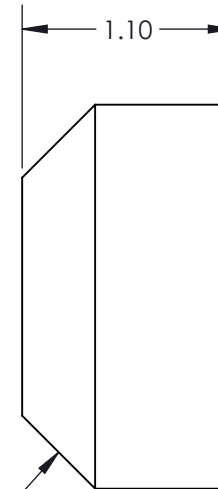
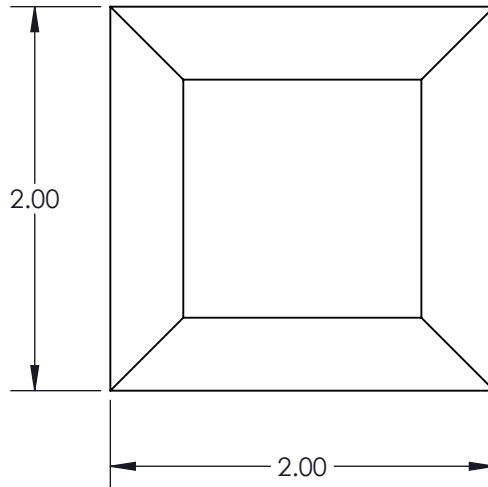
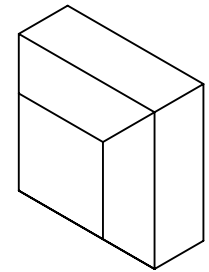
(-9)

ANCHOR POCKET

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-9	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH SEE -1 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:2	DATE 12/11/2015
SHEET 7 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



4X .38 X 45°

**SEE ATTACHED DEVIATION**

(-11)

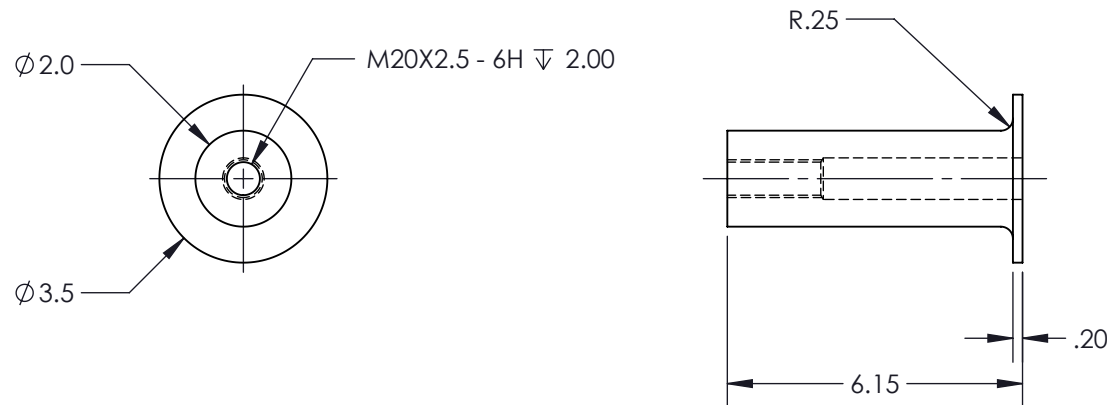
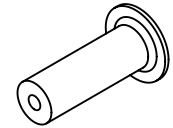
SQUARE LUG

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-11	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015
SHEET 8 OF 31	



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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



**SEE ATTACHED DEVIATION**

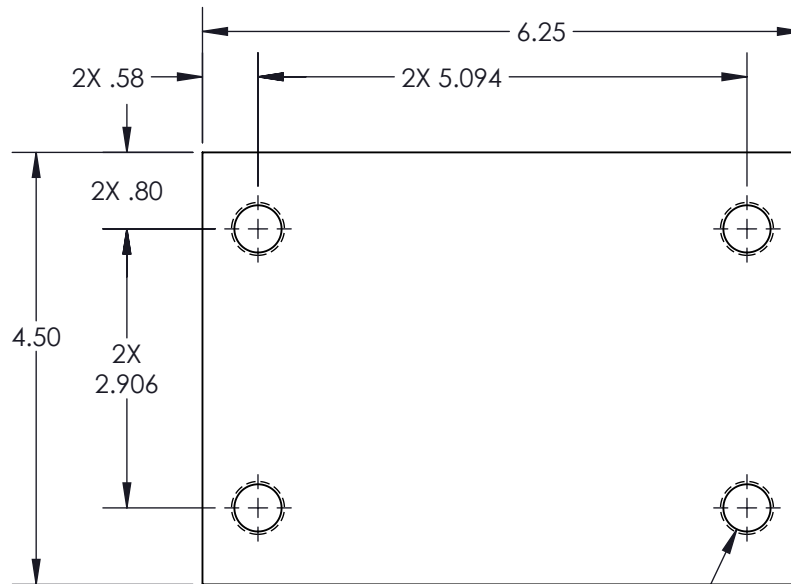
(-13)

JACKSCREW BASE

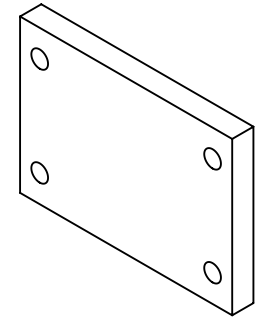
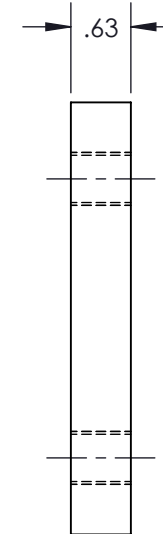
<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-13	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:4	DATE 12/11/2015
SHEET 9 OF 31	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE



4X M14X1.5 - 6H THRU ALL



**SEE ATTACHED DEVIATION**

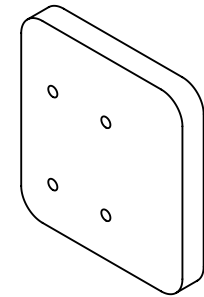
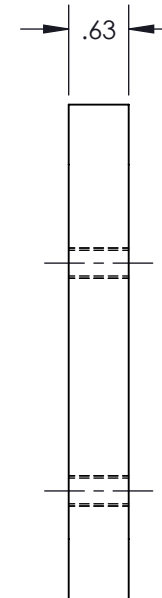
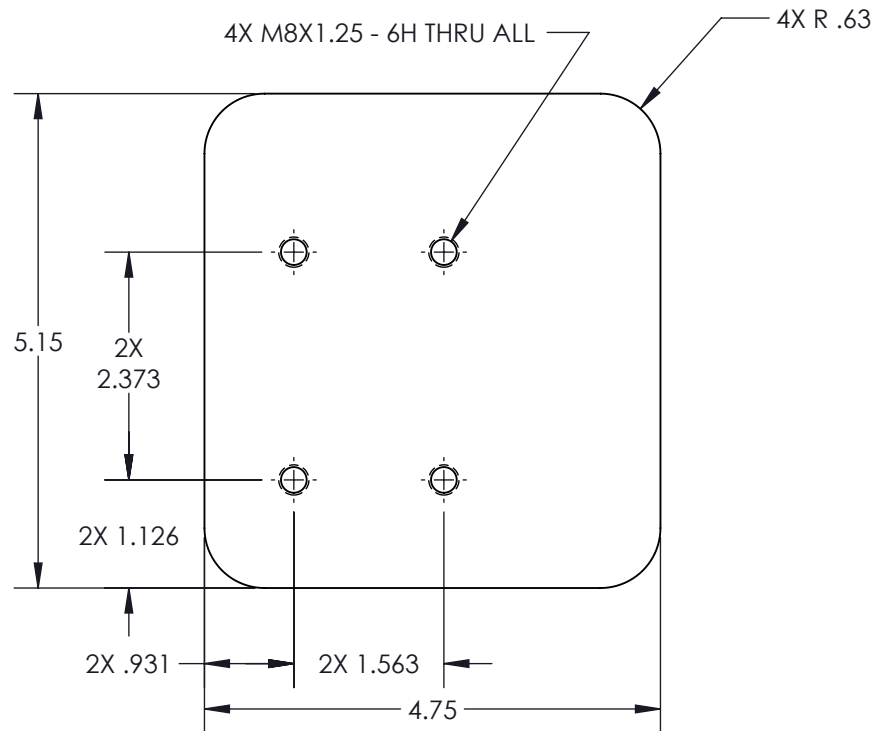
(15)

WHEEL PLATE

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-15	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:2	DATE 12/11/2015
	SHEET 10 OF 31

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				APPROVED



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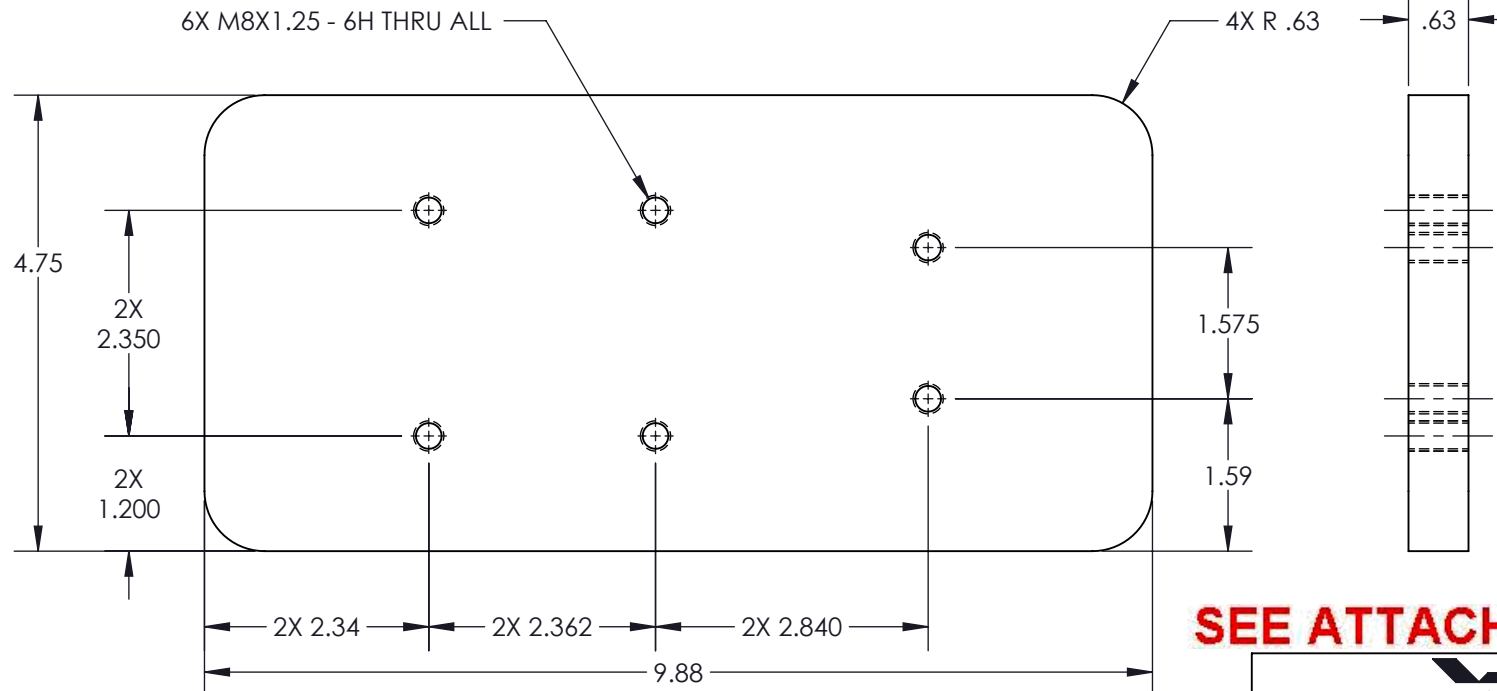
(17)

SMALL MOUNT PLATE

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-17	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/11/2015
SHEET 11 OF 31	

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				APPROVED



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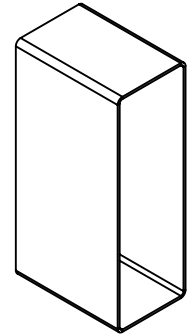
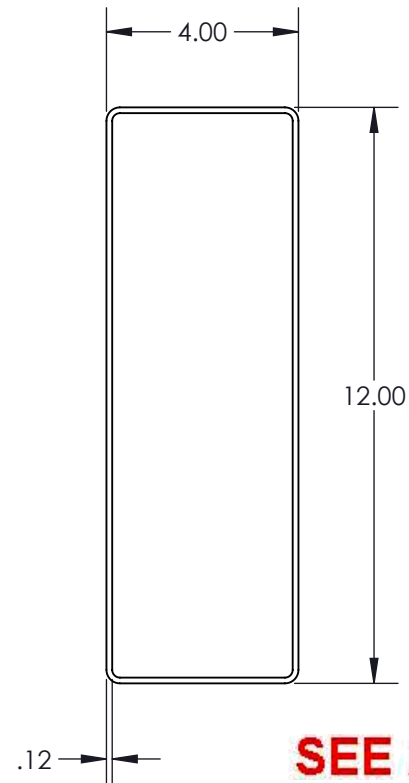
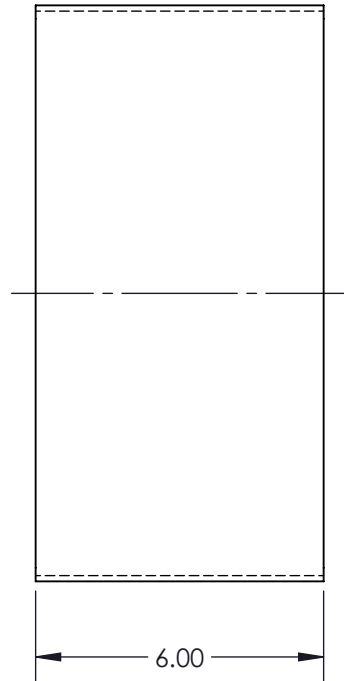
(19)

LARGE MOUNT PLATE

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-19	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:2	DATE 12/11/2015
	SHEET 12 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-21 CH'D DIM WAS .13 IS .12.	10/20/2016	SM	JAG



**SEE ATTACHED DEVIATION**

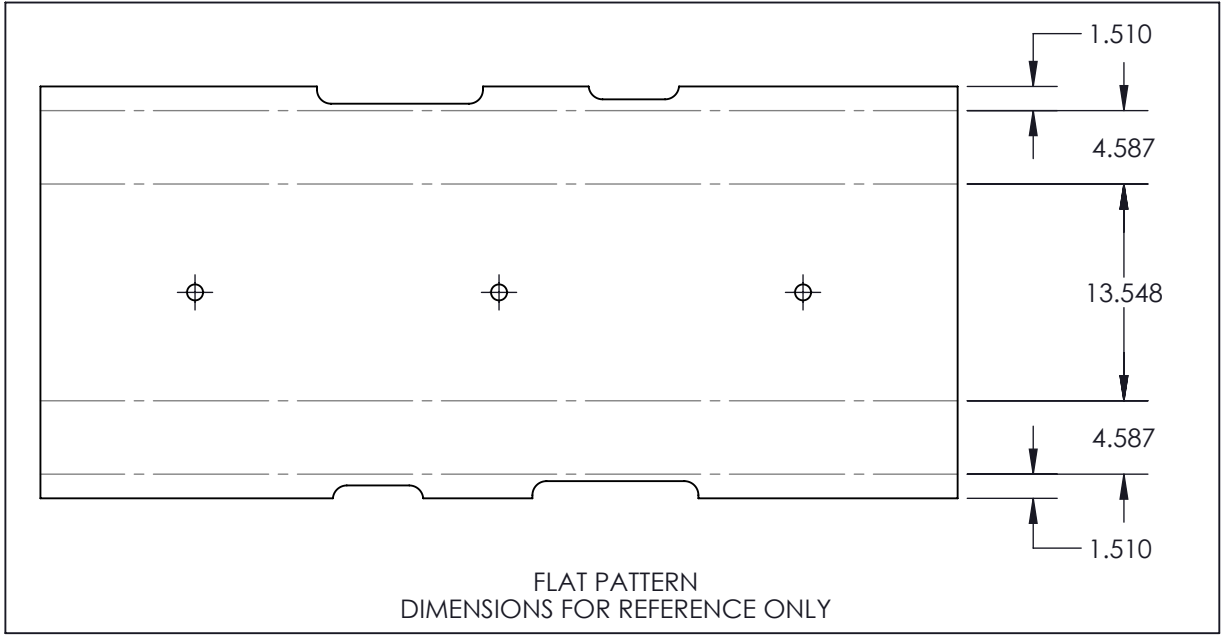
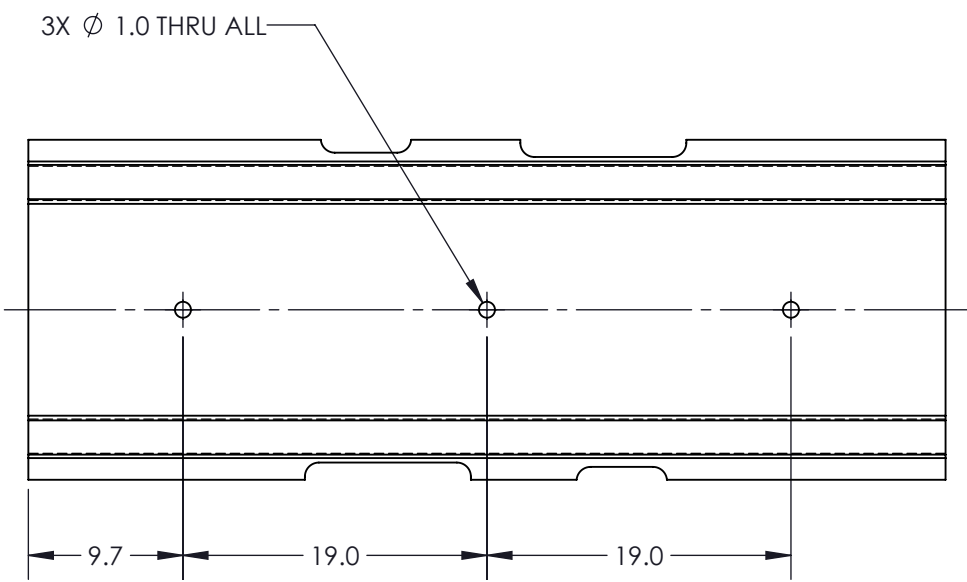
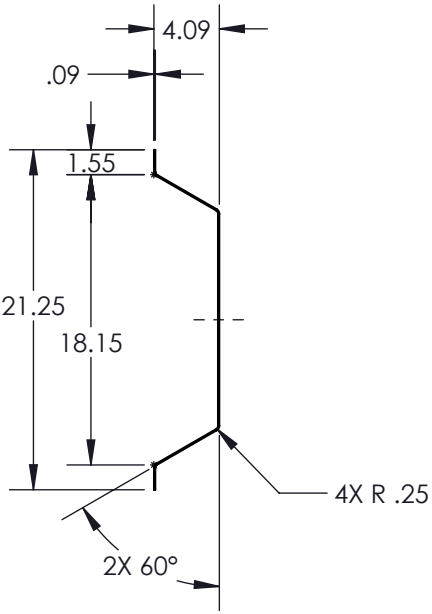
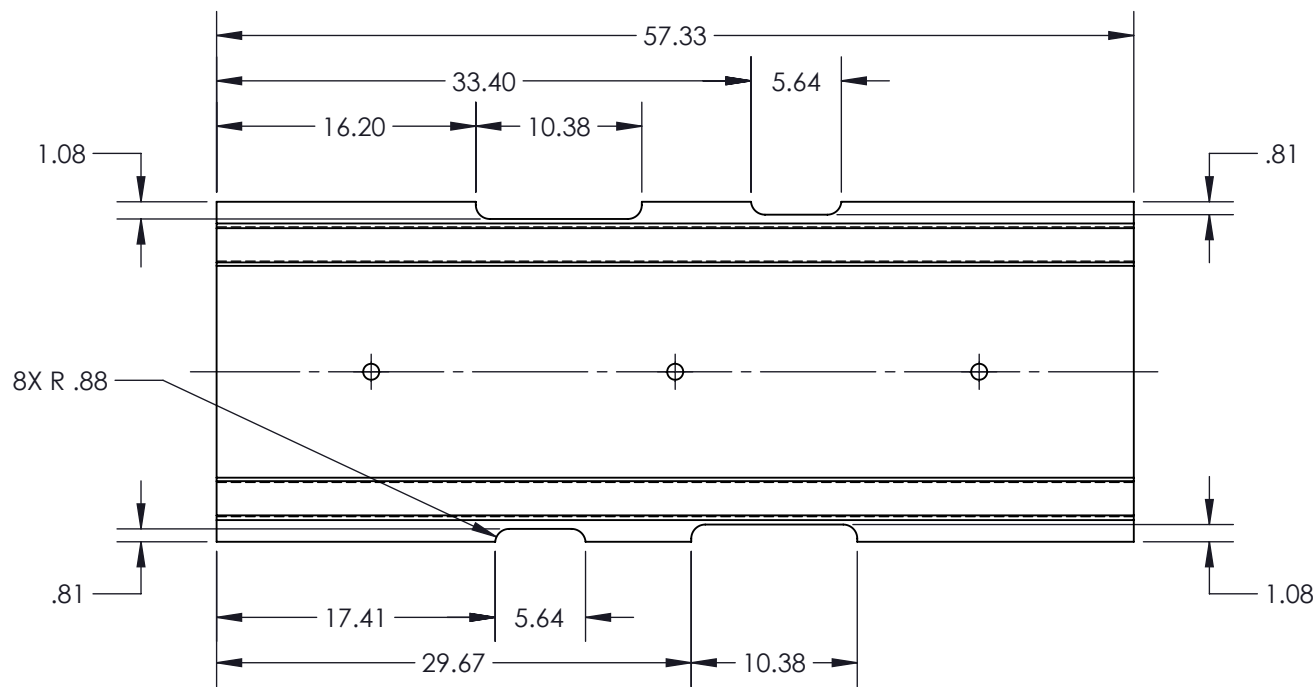
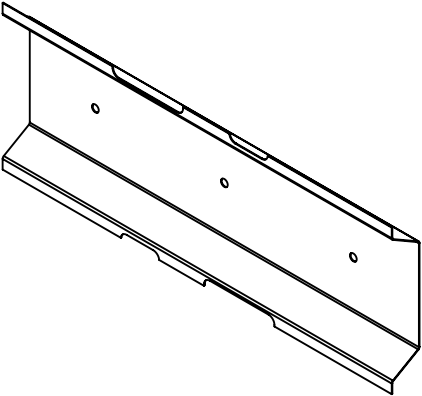
(-21)

FORK POCKET

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-21	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:4	DATE 12/11/2015
	SHEET 13 OF 31

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				APPROVED



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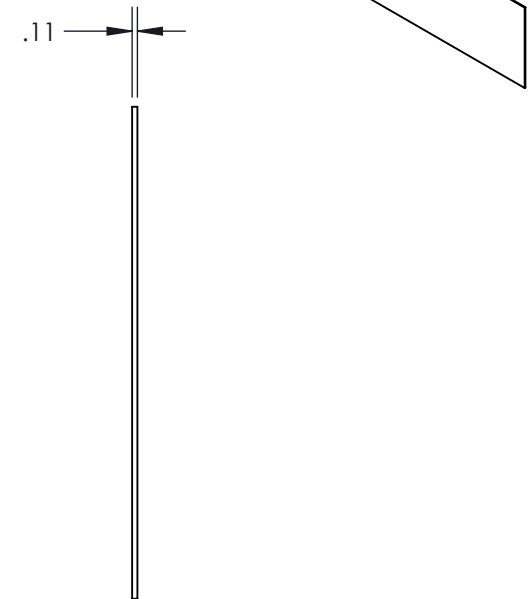
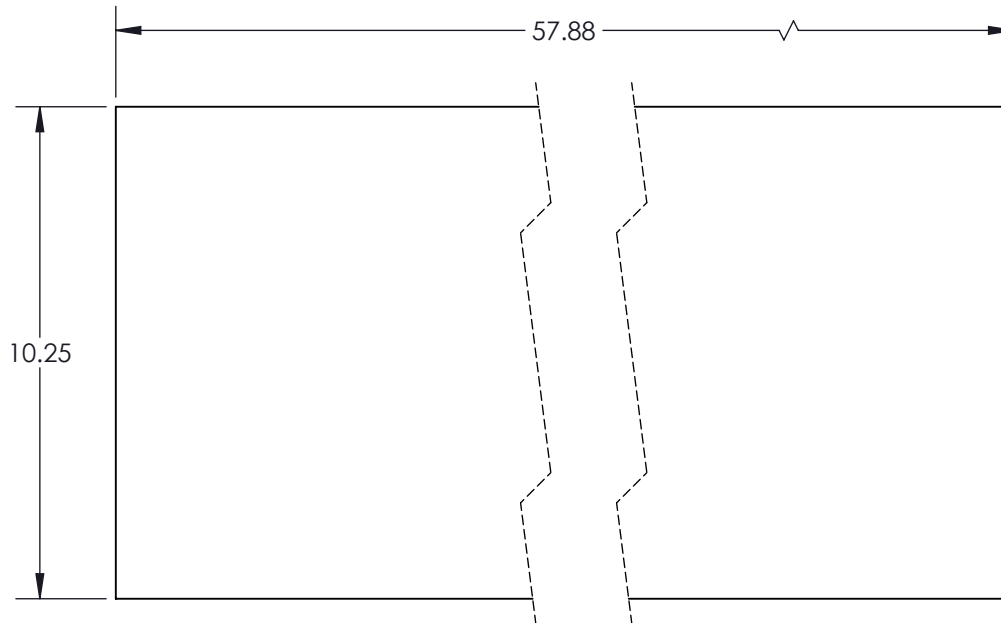
-23

BOTTOM PAN

DART AEROSPACE			
TITLE TRANSMISSION STAND			
DWG NO. RBEM632V1005102-23			REV 2
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .010	FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT		.XX ± .03	ANGLES ±1°
SPEC		.X ± .1	SURFACES = 125/
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE 1:12		DATE 12/11/2015	SHEET 14 OF 31

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-25 CH'D DIM WAS .09 IS .11.	10/20/2016	SM	JAG



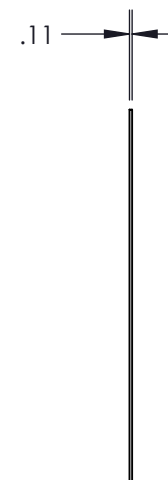
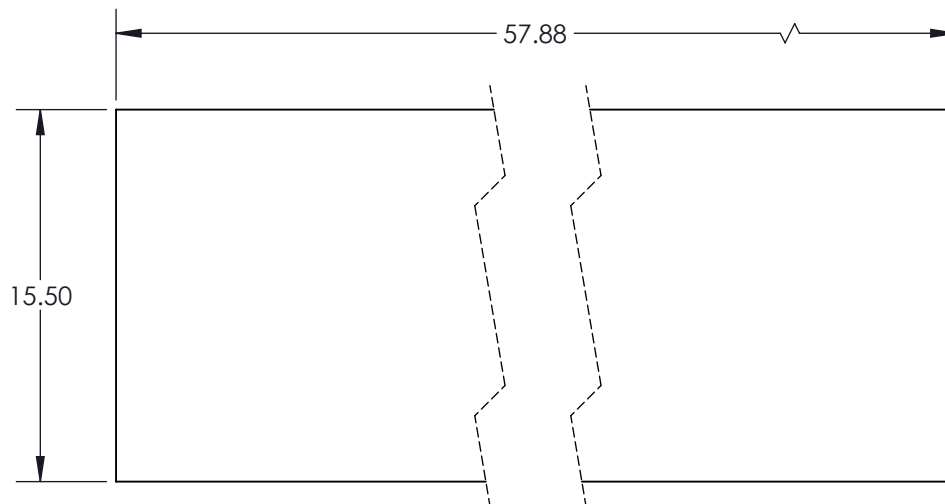
**SEE ATTACHED DEVIATION**

(-25)  
SMALL COVER

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-25	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:4	DATE 12/11/2015
SHEET 15 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-27 CH'D DIM WAS .09 IS .11.	10/20/2016	SM	JAG



**SEE ATTACHED DEVIATION**

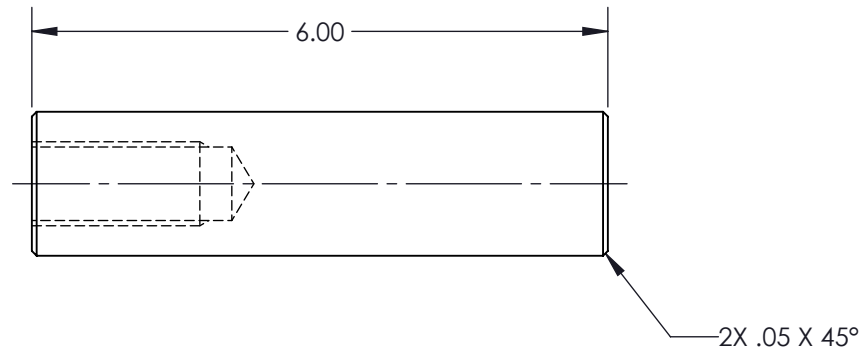
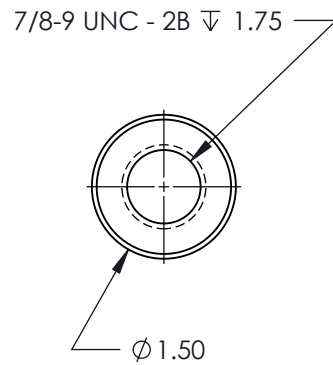
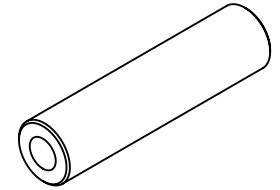
(-27)  
LARGE COVER

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-27	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:8	DATE 12/11/2015 SHEET 16 OF 31



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	18-0182	-29 CH'D DIM WAS M20X2.5 - 6H $\nabla$ 1.58 IS 7/8-9 UNC - 2B $\nabla$ 1.75	10/21/2016	SM	JAG



**SEE ATTACHED DEVIATION**

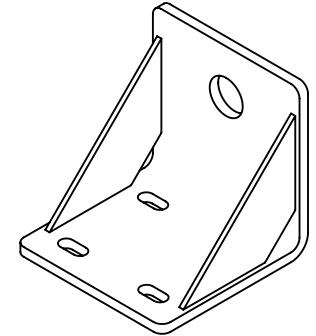
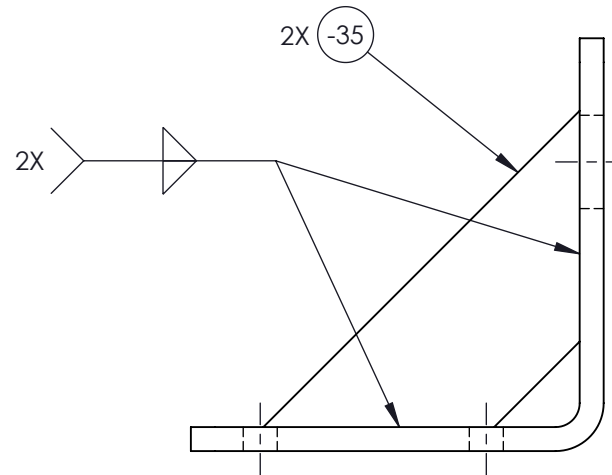
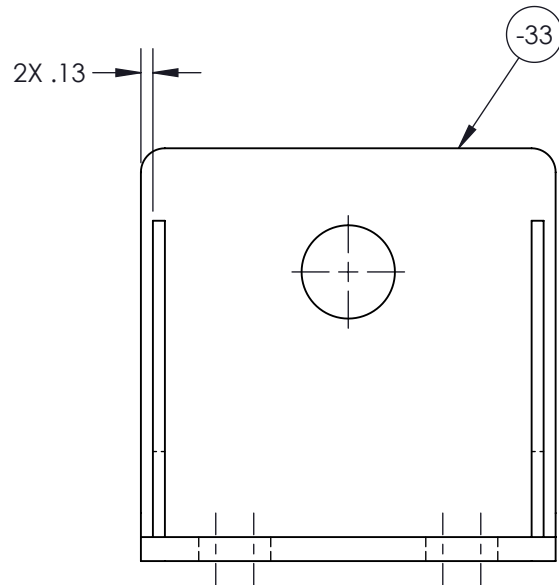
(-29)

TIE DOWN ANCHOR

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-29	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
FINISH SEE -1 WELDMENT	.XX $\pm$ .01 ANGLES $\pm$ 5°
SPEC	.X $\pm$ .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/11/2015
SHEET 17 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



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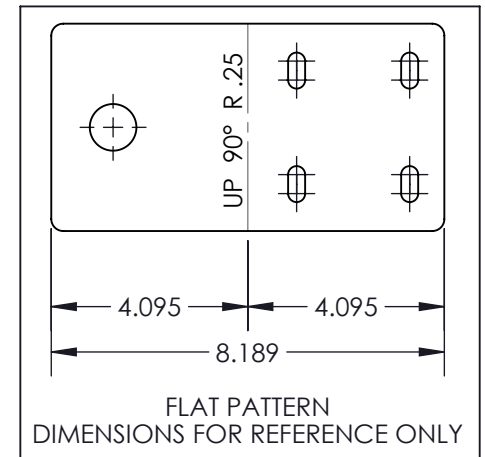
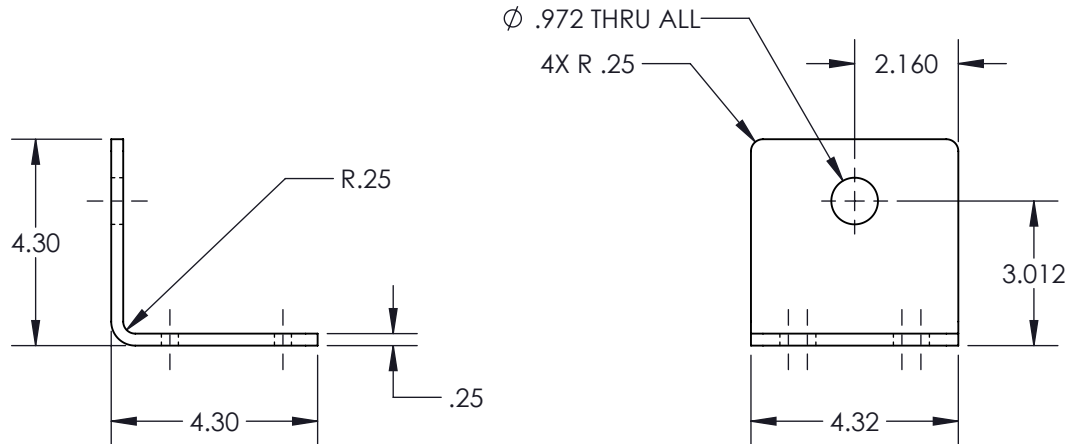
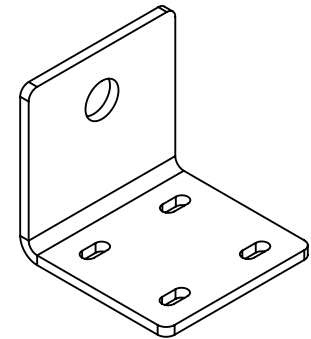
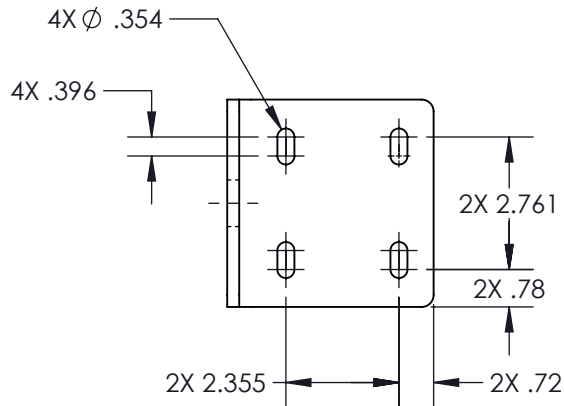
(-31)

BRACKET WELDMENT

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-31	REV 2
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC FED #13538	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:2	DATE 12/11/2015
SHEET 18 OF 31	

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			INITIAL
			APPROVED



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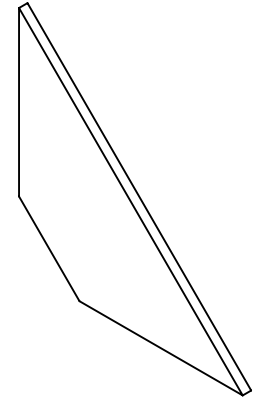
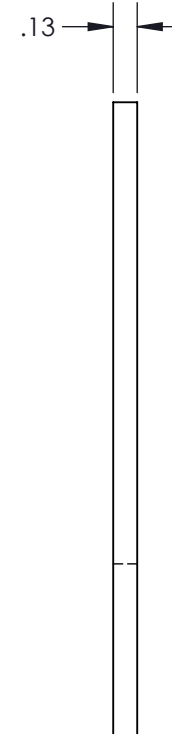
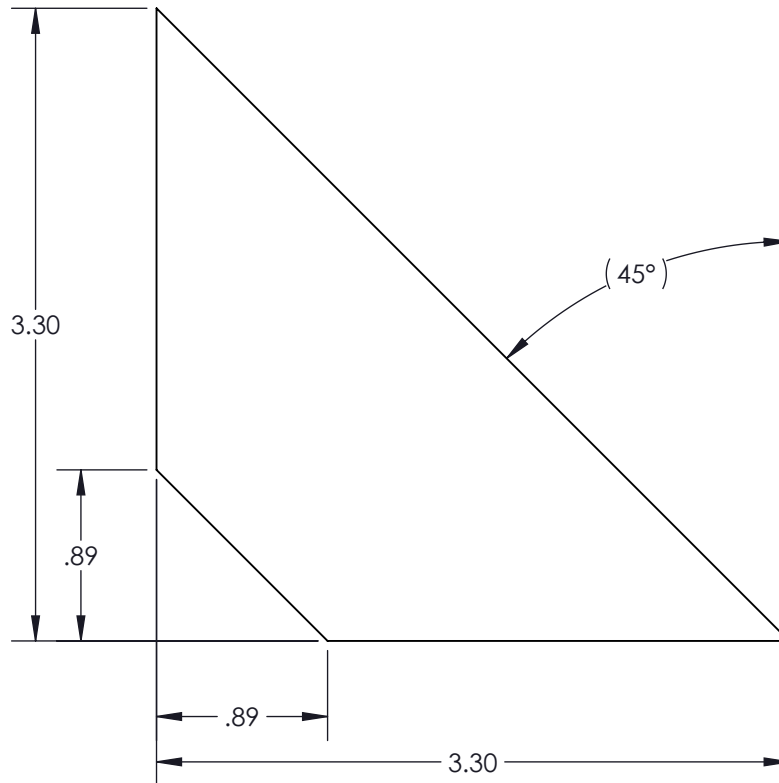
(33)

BRACKET

<b>DART AEROSPACE</b>	
TITLE <b>TRANSMISSION STAND</b>	
DWG NO. <b>RBEM632V1005102-33</b>	REV <b>2</b>
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE -31 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>DUERFELDT</b>	USED ON MODEL
CHECKED: <b>CLOUGH</b>	<b>H175</b>
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	
SCALE <b>1:4</b>	DATE <b>12/11/2015</b>
SHEET 19 OF 31	

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				APPROVED



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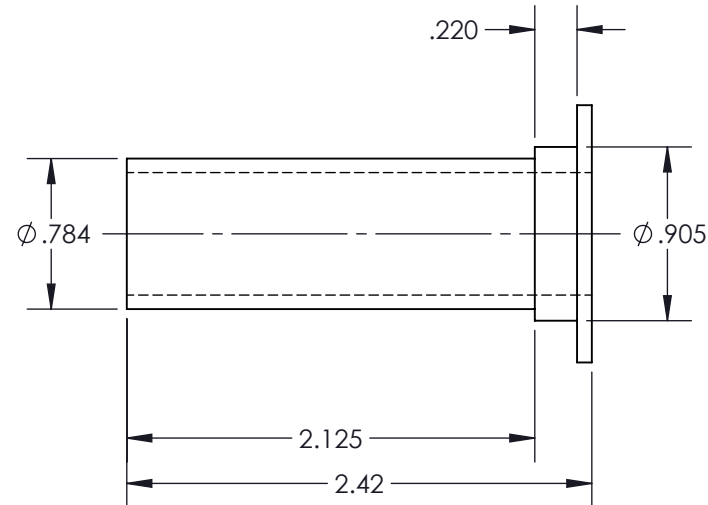
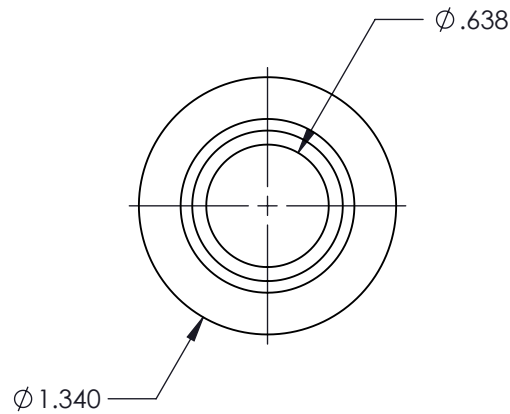
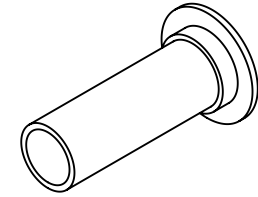
(35)

BRACKET GUSSET

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-35	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -31 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015
SHEET 20 OF 31	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



**SEE ATTACHED DEVIATION**

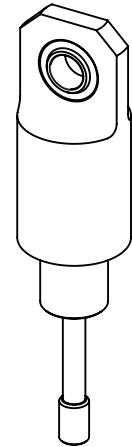
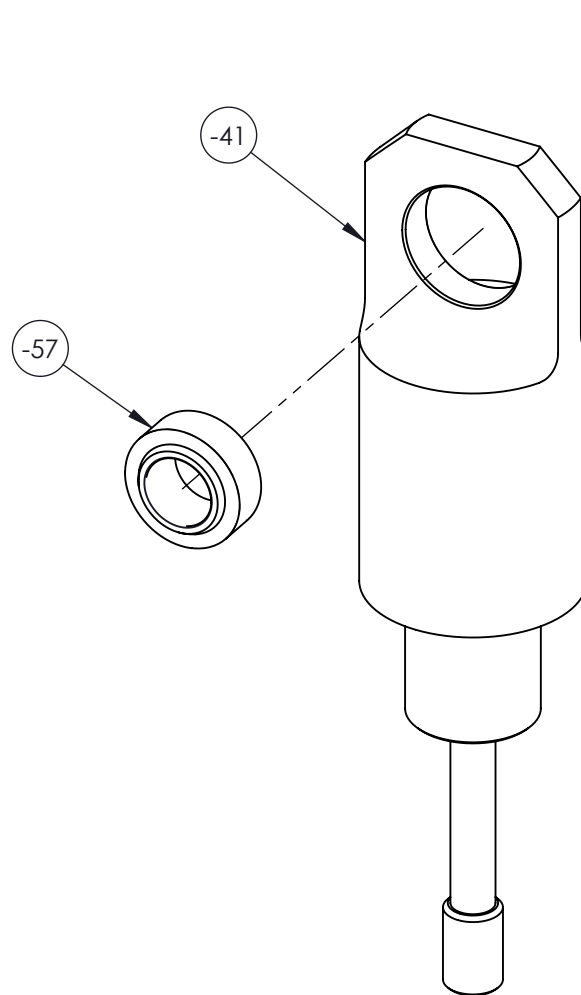
(-37)

BUSHING

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-37	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015
SHEET 21 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



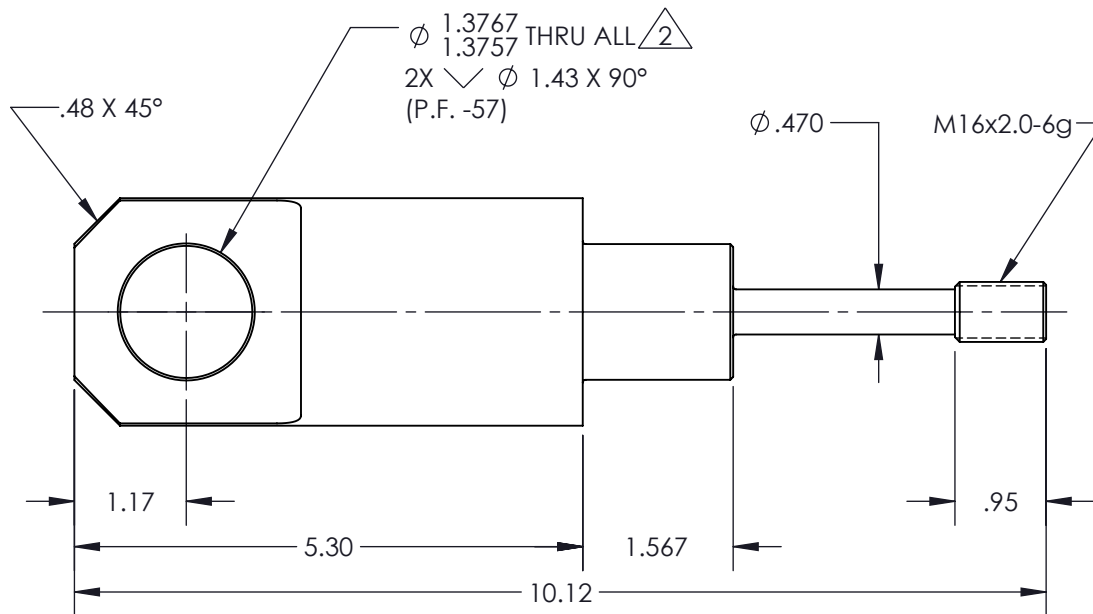
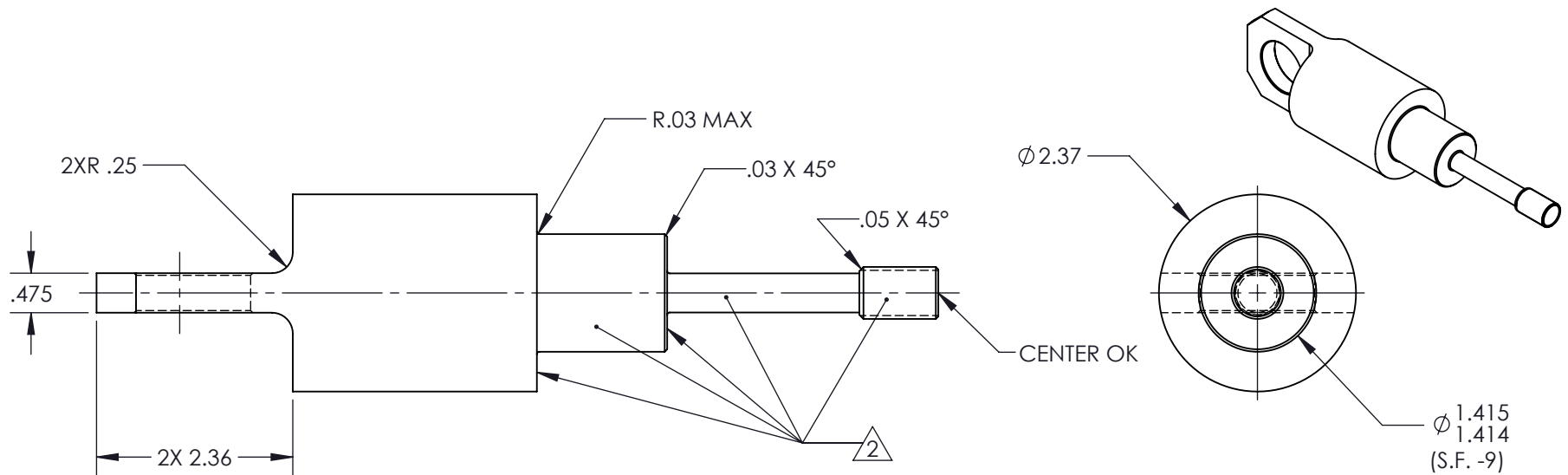
**SEE ATTACHED DEVIATION**

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-39	REV 2
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:2	DATE 12/11/2015 SHEET 22 OF 31

-39  
ANCHOR ASSEMBLY

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-41 ADDED DIM .05 X 45°; ADDED NOTE "CENTER OK".	10/20/2016	SM	JAG



(-41)  
ANCHOR

**SEE ATTACHED DEVIATION**

**NOTES:**

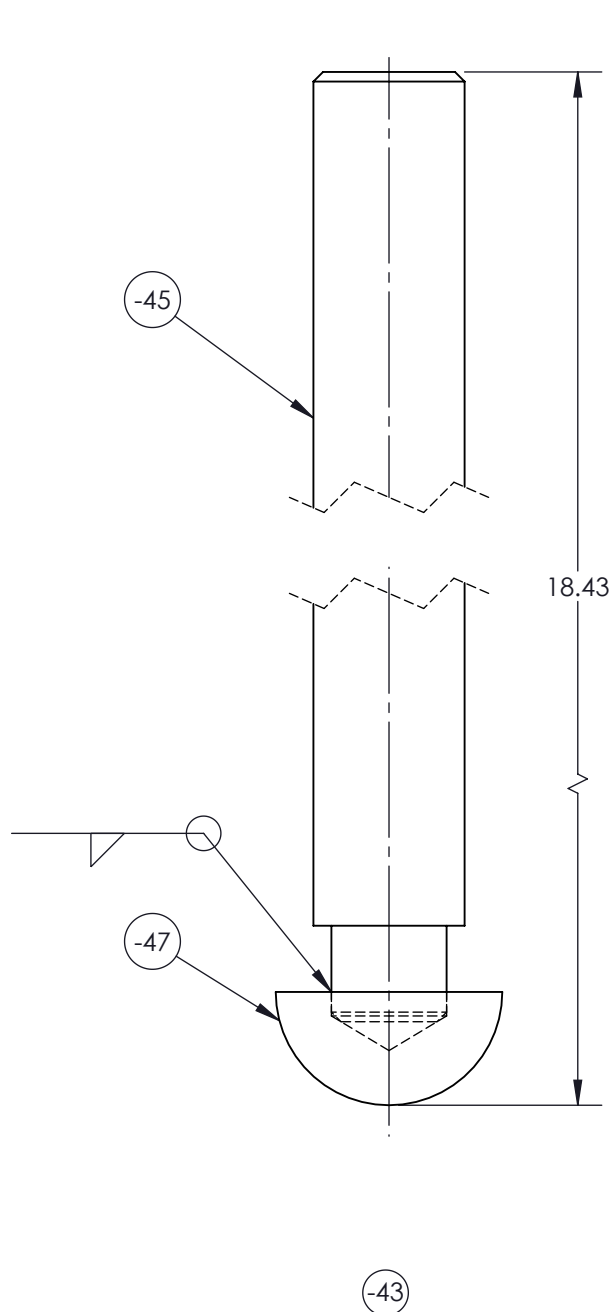
- DUAL FINISH:  
1ST: ZINC PLATE, ASTM B633 TYPE I SC2  
2ND: POWDER COAT YELLOW, FED #13538.

2 NO POWDER COAT THIS SURFACE.

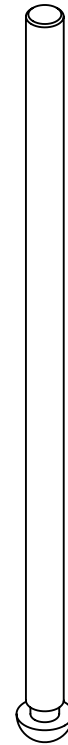
<b>DART AEROSPACE</b>	
TITLE <b>TRANSMISSION STAND</b>	
DWG NO. <b>RBEM632V1005102-41</b>	REV <b>2</b>
MAT'L 4140/4142 HEAT TREAT FINISH SEE NOTE 1 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL <b>H175</b>	
SCALE 1:2	DATE 12/11/2015
SHEET 23 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



JACKSCREW ROD WELDMENT



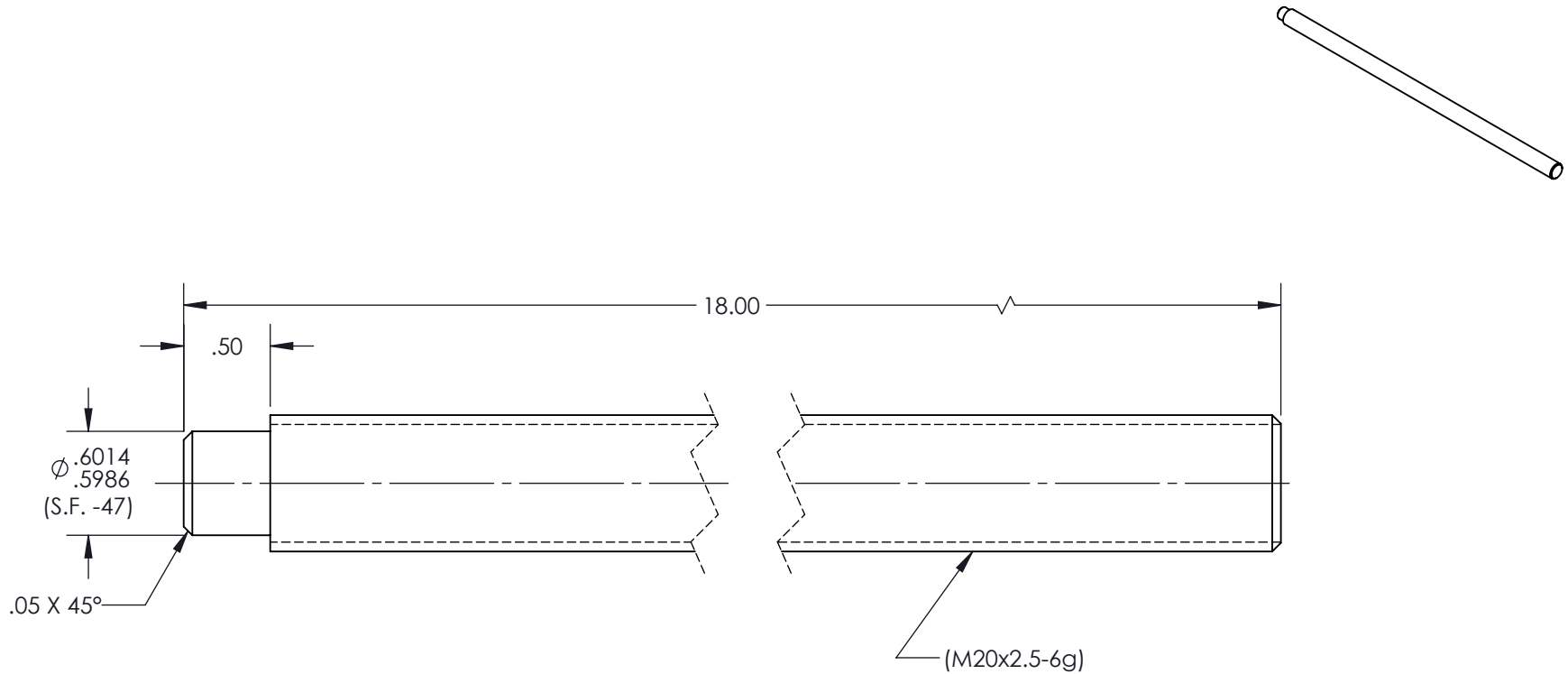
**SEE ATTACHED DEVIATION**

<b>DART AEROSPACE</b>	
TITLE <b>TRANSMISSION STAND</b>	
DWG NO. <b>RBEM632V1005102-43</b>	REV <b>2</b>
MAT'L <b>ZINC PLATE</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT <b>ASTM B633 TYPE I SC 2</b>	.XXX ± .010 FRACTIONS ± 1/8
FINISH <b>ASTM B633 TYPE I SC 2</b>	.XX ± .03 ANGLES ± 1°
SPEC <b>ASTM B633 TYPE I SC 2</b>	.X ± .1 SURFACES = 125
DRAWN BY: <b>DUERFELDT</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: <b>CLOUGH</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: <b>ANDERSON</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: <b>LINDSAY</b>	USED ON MODEL
APPROVED: <b>GILBERT</b>	<b>H175</b>
SCALE <b>1:1</b>	DATE <b>12/11/2015</b>
SHEET 24 OF 31	



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-45 CH'D DIM WAS Ø.6014/.5986 S.F. -47 IS Ø.6014/.5986 (S.F. -47).	10/20/2016	SM	JAG



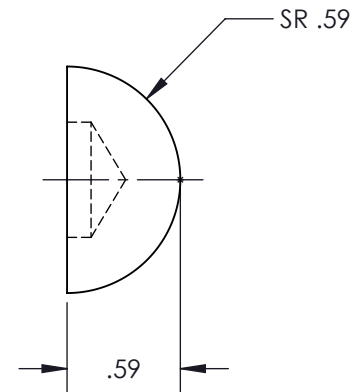
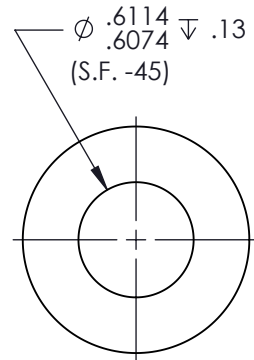
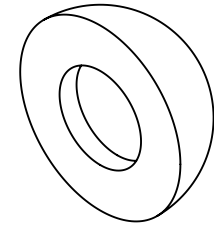
**SEE ATTACHED DEVIATION**

(-45)  
JACKSCREW ROD

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-45	REV 2
MAT'L B7	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -43 WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015
SHEET 25 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-47 CH'D DIM WAS Ø.6114/.6074 $\nabla$ .13 S.F. -45 IS Ø.6114/.6074 $\nabla$ .13 (S.F. -45).	10/20/2016	SM	JAG



**SEE ATTACHED DEVIATION**

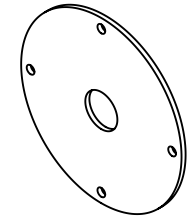
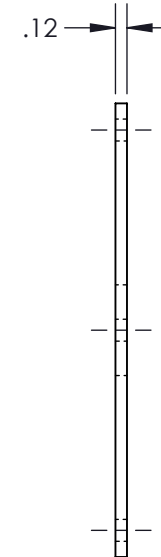
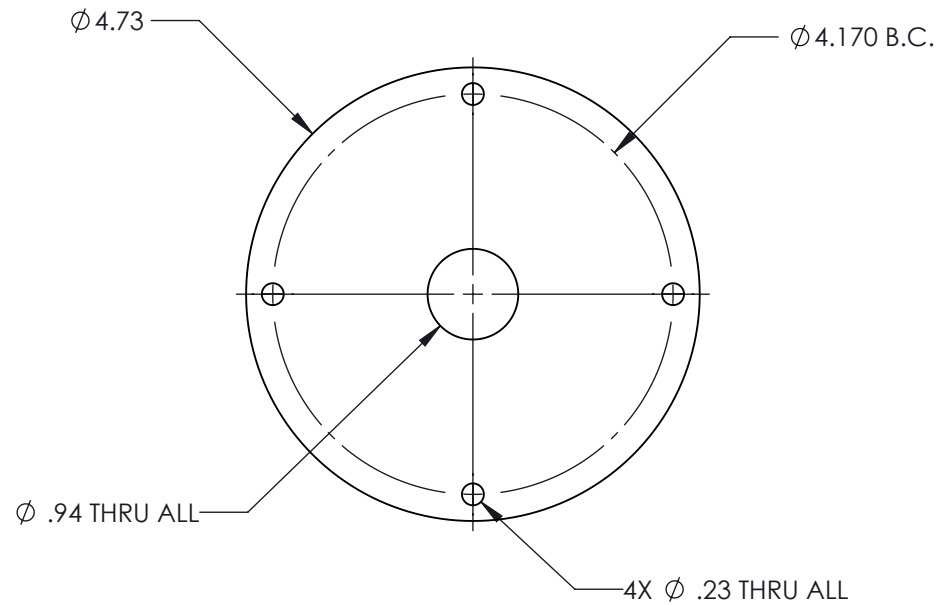
(-47)

JACKSCREW ROD PIVOT

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-47	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -43 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 12/11/2015	H175
SHEET 26 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



**SEE ATTACHED DEVIATION**

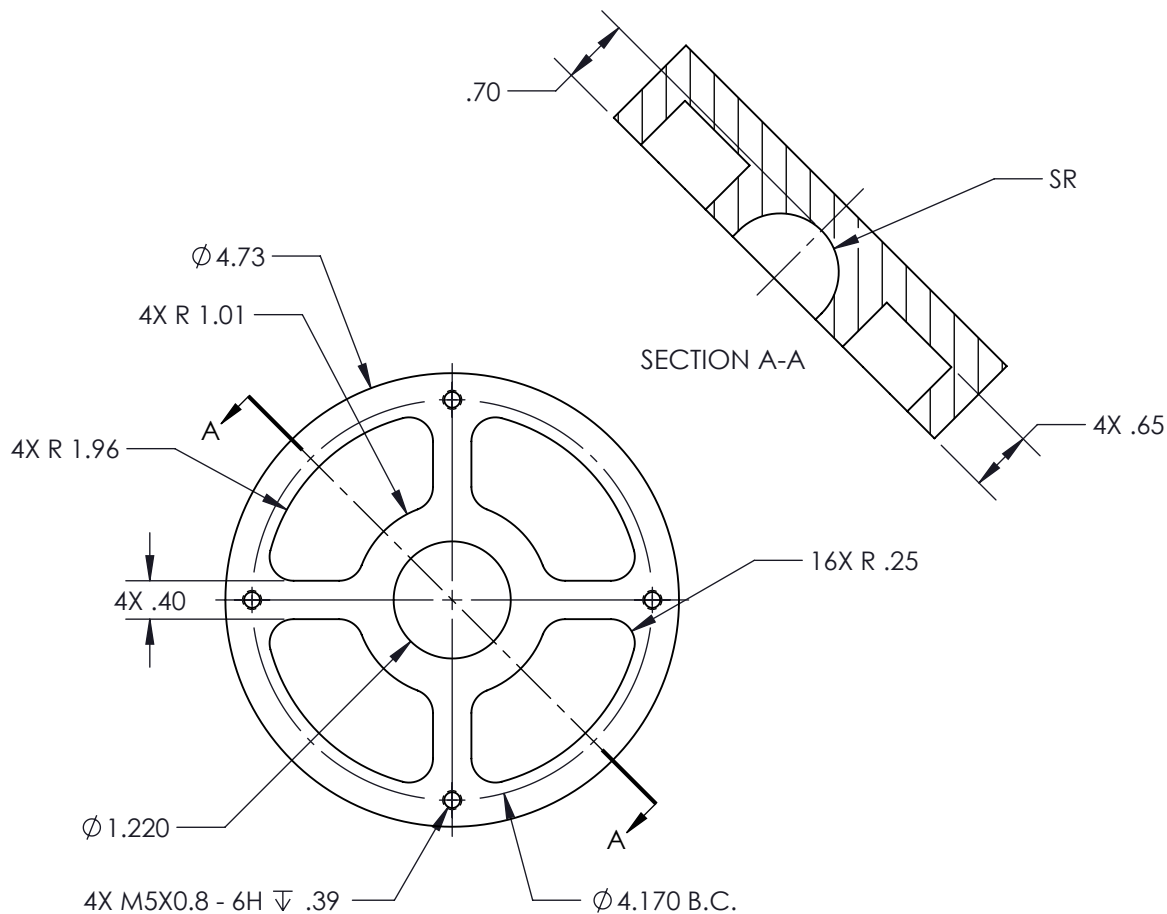
(-49)

JACKSCREW COVER

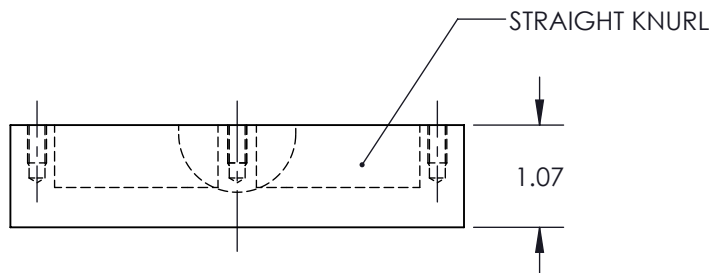
<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-49	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH POWDER COAT YELLOW	.XX ± .01 ANGLES ± 5°
SPEC FED #13538	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/11/2015
SHEET 27 OF 31	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



**SEE ATTACHED DEVIATION**



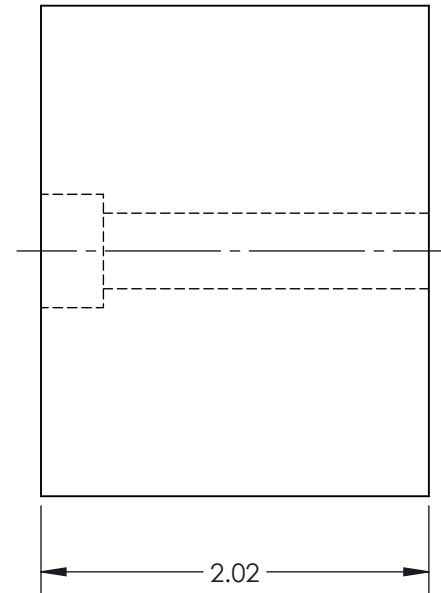
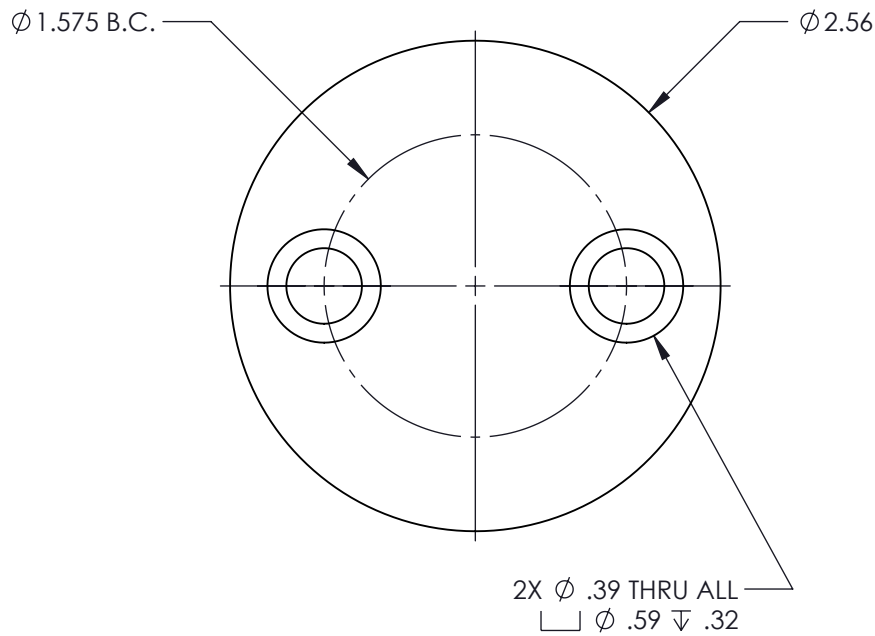
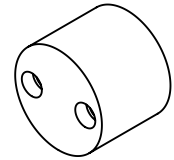
(-51)

JACKSCREW FOOT

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-51	REV 2
MAT'L 4140/4142 HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 12/11/2015
SHEET 28 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-53 CH'D DIM WAS 2X Ø.29 THRU ALL $\square$ Ø.43 $\nabla$ .25 IS 2X Ø.39 THRU ALL $\square$ Ø.59 $\nabla$ .32.	10/20/2016	SM	JAG



**SEE ATTACHED DEVIATION**

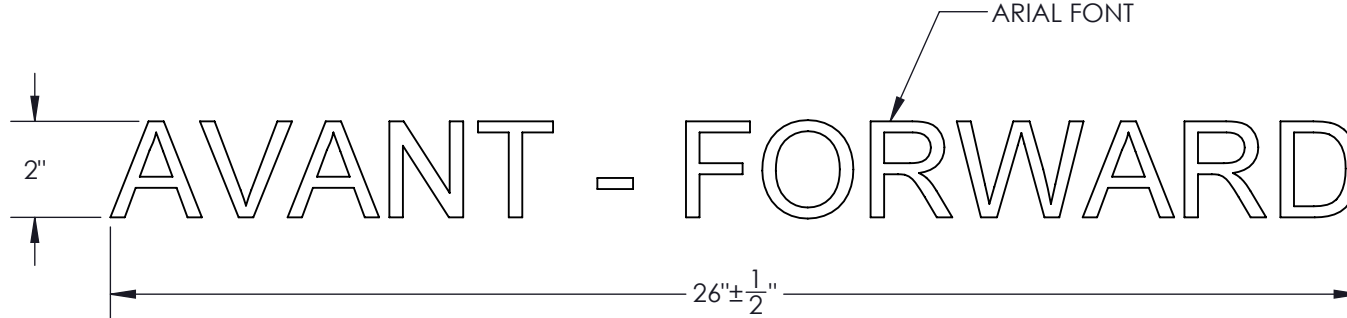
(-53)  
DELFIN PAD

<b>DART AEROSPACE</b>	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-53	REV 2
MAT'L WHITE DELRIN/ACETAL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/11/2015
SHEET 29 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-89 ADDED TO BOM QTY 1. ADDED DRAWING.	2/3/2017	SM	JAG

AVANT - FORWARD



SEE ATTACHED DEVIATION

-89

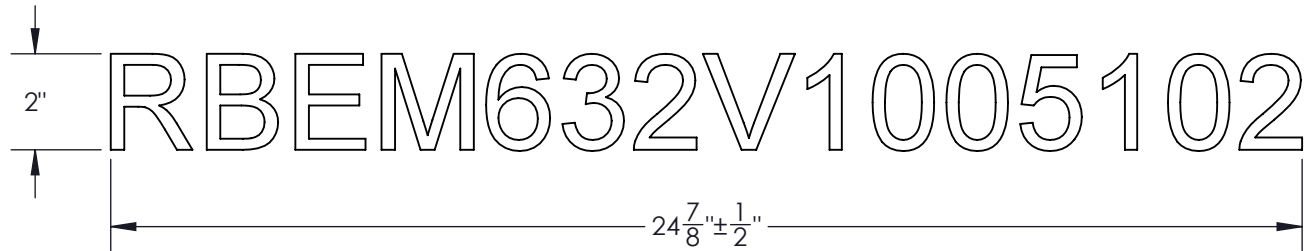
LABEL

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-89	REV 2
MAT'L BLACK CUT, VINYL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	USED ON MODEL
APPROVED:	H175
SCALE 1:4	DATE 1/18/2017
SHEET 30 OF 31	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0182	-91 ADDED TO BOM QTY 1. ADDED DRAWING.	2/3/2017	SM	JAG

RBEM632V1005102



**SEE ATTACHED DEVIATION**

(-91)

LABEL

<b>DART</b> AEROSPACE	
TITLE TRANSMISSION STAND	
DWG NO. RBEM632V1005102-91	REV 2
MAT'L BLACK CUT, VINYL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT FINISH	DIMENSIONS ARE IN INCHES
SPEC	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
DRAWN BY: CLOUGH	.XX $\pm$ .03 ANGLES $\pm$ 1°
CHECKED:	.X $\pm$ .1 SURFACES = 125
OPPS APPR:	1. BREAK ALL SHARP EDGES
QA APPR:	.015 x 45° OR .015R
APPROVED:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:4	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 1/18/2017	USED ON MODEL
SHEET 31 OF 31	H175

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. <u>RBEM632V1005102 REV. 2</u>	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>		
Date : _____	Sequence #: _____	QTY Affected : _____		<b>MRB (QSI042)</b>  <b>AUGUST 17, 2018</b>
<b>Description Work Order Deviation</b>		<b>Disposition</b>		
<b>RBEM632V1005102-3 /-5 /-7:</b> - MATERIAL WAS STEEL, IS ASTM A500 REC. TUBING  <b>RBEM632V1005102-21:</b> - MATERIAL WAS STEEL, IS ASTM A500 REC. TUBING -WALL THICKNESS WAS .12 IS .19  <b>RBEM632V1005102-25 /-27:</b> - THICKNESS WAS .11 IS 11 GA. (.1196")  <b>RBEM632V1005102-23:</b> - THICKNESS WAS .09 IS 13 GA. (.0897")  <b>RBEM632V1005102-29 /-37 /-41 /-51:</b> - WAS 4140/4142 IS 4140/4142 (28-32 Rc)  <b>RBEM632V1005102-51:</b> - WAS WHITE DELRIN/ACETAL IS WHITE DELRIN/ACETAL ASTM D6100  <b>RBEM632V1005102-89 /-91:</b> - MATERIAL WAS BLACK CUT VINYL IS 3M #180C-12 BLACK ADHESIVE-BACKED VINYL		This deviation is acceptable.   The fit, form and function of the part will be as originally intended.       <div style="text-align: center;">PER VM</div>		<b>Completed By</b>   <b>Lead hand / Supervisor</b>   <b>QC / QA Coordinator</b>
<b>Root Cause</b>		<b>FAULT CATEGORY</b>		
<div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input checked="" type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input checked="" type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>		
		Other/Details:		